

Work Order ID 47002B

September 11, 2009 8:40:07 AM



Page 1

Item ID: D3186-4

Accept



Setup Start



Revision ID: D

Stop



Item Name: Spacepod Door, RH

Start Date: 9/11/09 Start Qty: 1.00



Cust Item ID:

Required Date: 9/11/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3186	Rev D

100



Small Fab

0.00

✓

Small Fab

Memo

0.00

Small Fab

I-Drill holes and cut out slots for latch as per dwg D3186 (D3186-4 detail)

110



QC5- Inspect part completeness to step on W/O

0.00

✓

QC

Memo

0.00

Quality Control

120



Identify as per dwg & Stock Location: _____

0.00

✓

Packaging

Memo

0.00

Packaging

Picklist Print

Page 1

September 11, 2009 8:40:06 AM

Work Order ID: 47002B



Parent Item: D3186-4RevD



Parent Item Name: Spacepod Door, RH

Start Date: 9/11/09

Required Date: 9/11/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3186-2MRevD		Manufactured	No			100	Each	2.0000	1.0000			

SPACEPOD DOOR RH



Warehouse Loc Qty Loc Code

Location

Main Warehouse

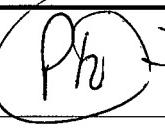
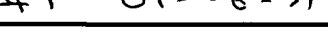
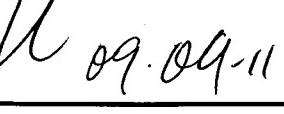
CA	2	_____
47002B01	1	_____
48150C01	1	_____

D350-600-242

Dart Aerospace Ltd.

Date: Tuesday, 07/04/2009 10:28:22 AM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SPACEPOD DOOR RH		
Job Number	: 47002B						
Estimate Number	: 12636						
P.O. Number	:			Part Number	: D31864		
This Issue	: 07/04/2009	S.O. No.	:	Drawing Number	: D3186 REV.D		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: / /	Type	: SMALL /MED FAB	Drawing Revision	: D		
Previous Run	: 46180B			Material	:		
Written By	:			Due Date	: 10/05/2009		
Checked & Approved By	: JWD 09.04.07			Qty:	1	Um:	Each
Comment	: Est Rev:A New Issue 07-01-11 EC est rev.B revD 07.03.07 ec						
Additional Product							
Job Number: 							
Seq. #:	Machine-Qr Operation:	Description :					
1.0	47002B01	SPACEPOD DOOR RH 					
Comment: Sub-Component SPACEPOD DOOR RH 1 x D3186-2M Batch <u>47002B01</u>							
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  					
Comment: SMALL & MEDIUM FAB RESOURCE 1							
1-Drill holes and cut out slots for latch as per dwg D3186 (D3186-4 detail) 							
3.0	QC5	INSPECT WORK TO CURRENT STEP 					
Comment: INSPECT WORK TO CURRENT STEP <u>S 07/09/01</u>							
4.0	PACKAGING 1	PACKAGING RESOURCE #1 					
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>45540</u> 							
5.0	QC21	FINAL INSPECTION/W/O RELEASE 					
Comment: FINAL INSPECTION/W/O RELEASE <u>09/09/11</u>							
Job Completion 							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.09.01	Z	CUT SLOTS 1.10 FROM EDGE INSTEAD OF 0.98	BT 09/08 -31			G 09.09.01 QSI 04/2	S 09/08/01

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

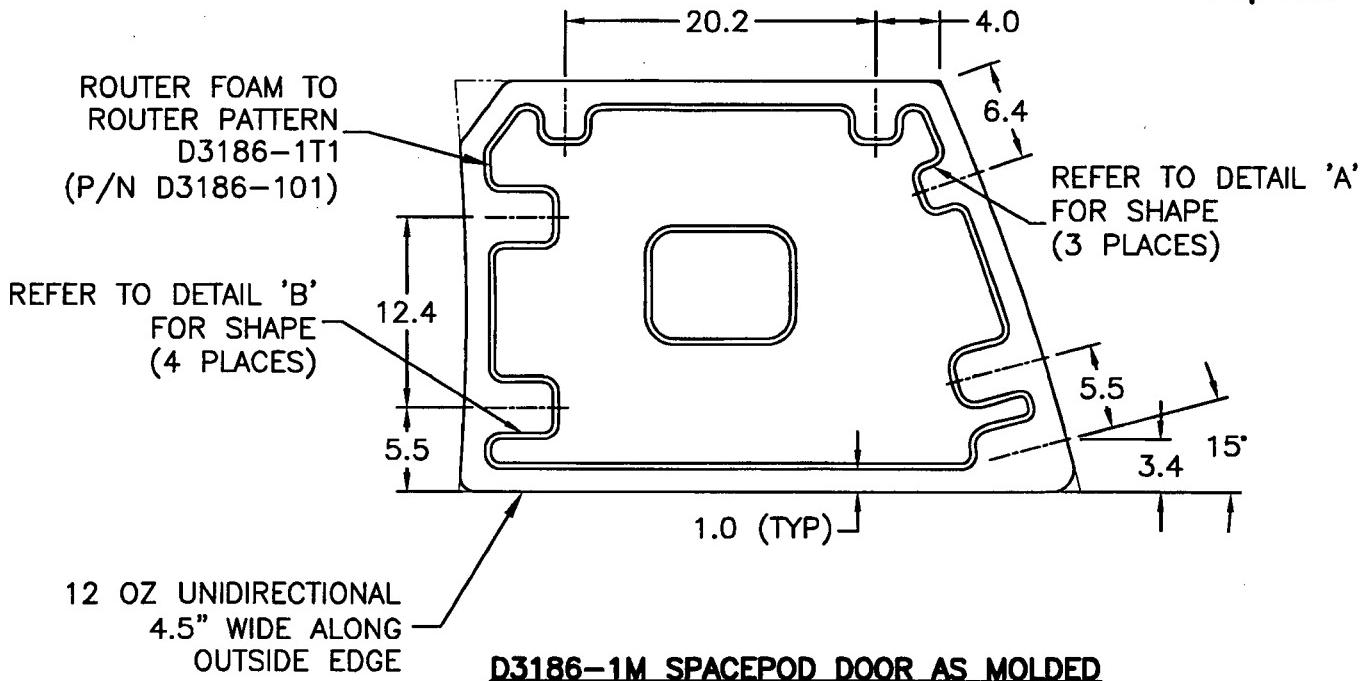
NOTE: Date & initial all entries

DART

DESIGN DS	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

MAIN LAYUP
 9 OZ SATIN (9 SQ FEET)
 9 OZ SATIN (9 SQ FEET)
 FOAM
 9 OZ SATIN (9 SQ FEET)
 12 OZ UNIDIRECTIONAL
 9 OZ SATIN (9 SQ FEET)
 RESIN (35-45% BY WEIGHT)
 PEEL PLY

A	03.03.27	NEW ISSUE
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED
C	06.12.13	REMOVED D0600-XXX LABELS
D	07.02.22	UPDATE DIMENSIONS

RELEASED07.02.27 *H*NOTES:

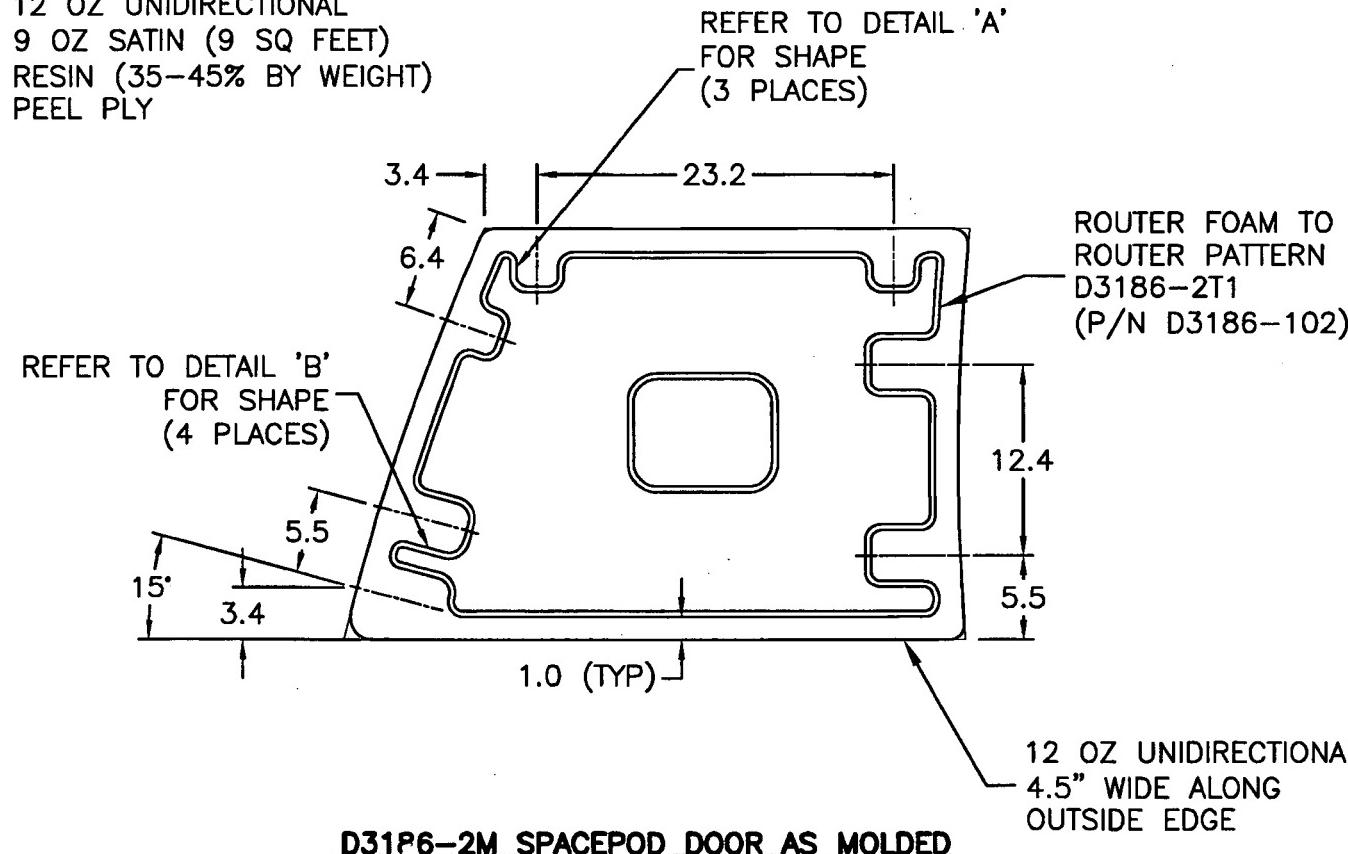
- 1) USE MOLD DT8005 FOR DOOR LAYUP
 - 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
 - 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECCELL
 - 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
 - 5) LAMINATE PER DART QSI 006 4.0
 - 6) LAMINATION SCHEDULE PER THIS DRAWING
 - 7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
 - 8) ALL DIMENSIONS ARE IN INCHES
 - 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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DATE 07.02.22	TITLE SPACEPOD DOOR	SCALE NTS	

MAIN LAYUP

9 OZ SATIN (9 SQ FEET)
 9 OZ SATIN (9 SQ FEET)
 FOAM
 9 OZ SATIN (9 SQ FEET)
 12 OZ UNIDIRECTIONAL
 9 OZ SATIN (9 SQ FEET)
 RESIN (35-45% BY WEIGHT)
 PEEL PLY

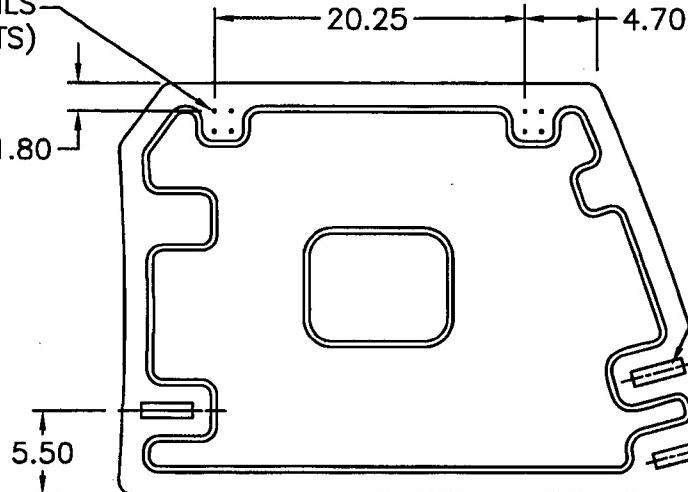
RELEASED07.02.27 *CH*NOTES:

- 1) USE MOLD DT8006 FOR DOOR LAYUP
 - 2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
 - 3) FOAM: 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECCELL
 - 4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
 - 5) LAMINATE PER DART QSI 006 4.0
 - 6) LAMINATION SCHEDULE PER THIS DRAWING
 - 7) FINISH INSIDE/OUTSIDE WITH DUPONT Highbuild GREY PRIMER 1144-S
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CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3186	REV. D SHEET 3 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

REFER TO DETAIL 'C'
FOR HOLE DETAILS
(2 SETS)

**RELEASED**07.02.27 *CH*

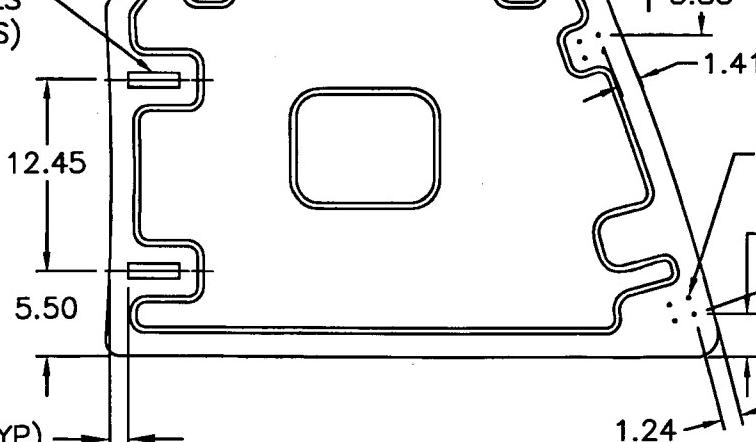
REFER TO DETAIL 'D'
FOR CUTOUT DETAILS
(3 PLACES)

D3186-1 SPACEPOD DOOR, LH
(MAKE FROM D3186-1M)

REFER TO DETAIL 'D'
FOR CUTOUT DETAILS
(2 PLACES)

REFER TO DETAIL 'C'
FOR HOLE DETAILS

CH 05.05.01



REFER TO DETAIL 'E'
FOR HOLE DETAILS
(2 SETS)

D3186-3 SPACEPOD DOOR, LH
(MAKE FROM D3186-1M)

NOTES:

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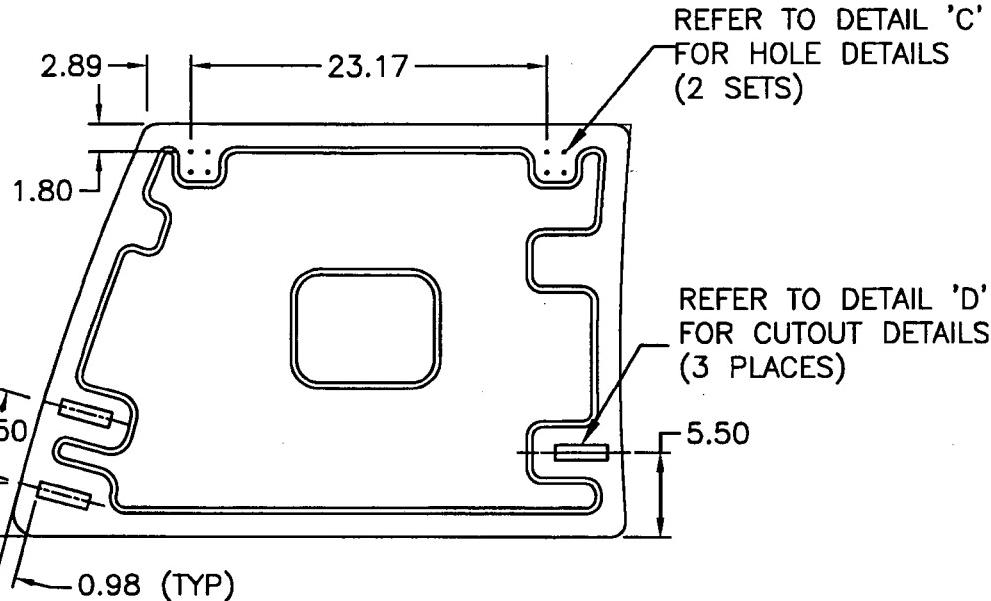
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WHEN CHANGED

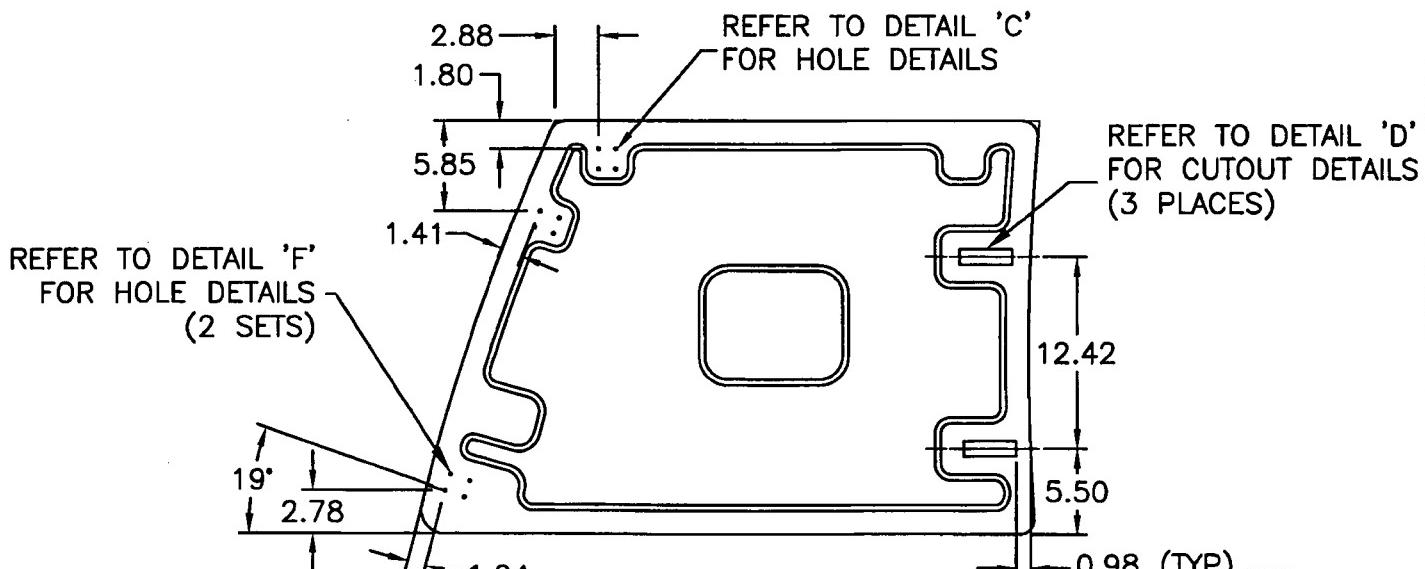
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DATE 07.02.22	TITLE SPACEPOD DOOR	SCALE NTS	

RELEASED07-02-27 *CH*

D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

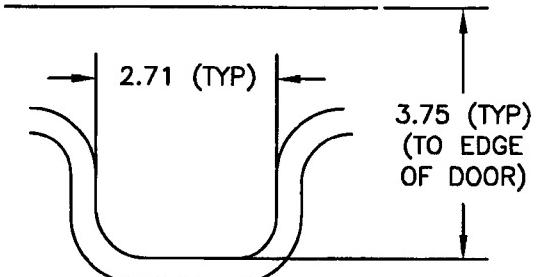
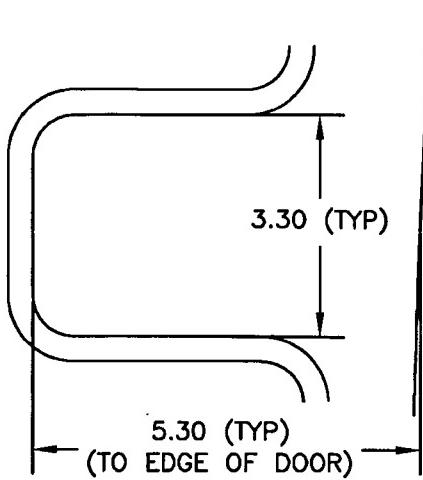
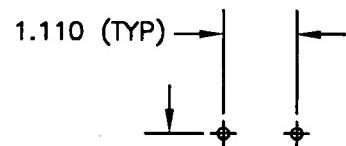
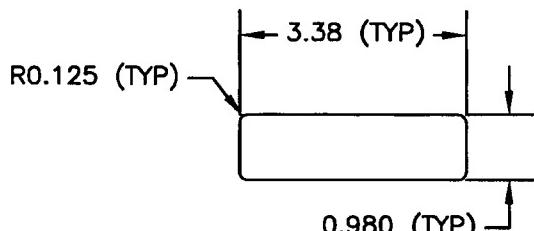
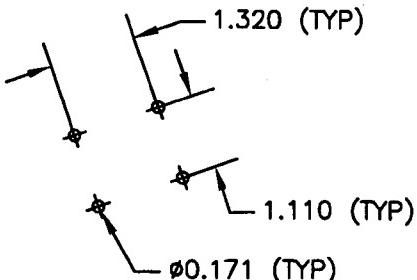
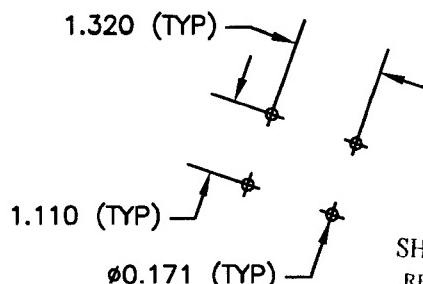
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DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

**DETAIL A****DETAIL B****RELEASED**07.02.27 *CH***DETAIL C**NOTE: ENSURE THAT CUTOUT IS
PERPENDICULAR TO EDGE OF DOOR**DETAIL D****DETAIL E**

SHOP COPY
RETURN TO
Engineering
UNCONTROLLED COPY
STAY OFF THE GROUND
WITHIN 100' OF DOOR
VIA AIRPORT
NO. 470023

NOTES:

- 1) ALL DIMENSIONS ARE IN INCHES
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